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<p>(54) Title: EDIBLE PRODUCTS HAVING INORGANIC COATINGS</p> <p>(57) Abstract</p> <p>An edible product having a thin inorganic coating on at least a portion of its surface. The coating preferably forms a moisture/oxygen barrier to result in a coated edible product having an improved shelf-life. The edible products include food and pharmaceuticals. The inorganic materials used for the coating include SiO₂, SiO, MgO, CaO, TiO₂, ZnO and MnO. Processes and apparatuses for depositing a thin film of inorganic material onto an edible substrate are also disclosed. The preferred processes include sputtering and vapor deposition. The preferred apparatus provides for the continuous production of coated edible products.</p> <p style="text-align: center;">BEST AVAILABLE COPY</p>		

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EDIBLE PRODUCTS HAVING INORGANIC COATINGS**BACKGROUND OF THE INVENTION****Field of the Invention**

5 This invention relates to edible products, such as a food or a pharmaceutical composition, which are coated with edible inorganic films. The invention also relates to a method of producing an edible product having an inorganic coating, and an apparatus for processing edible products coated with an inorganic film.

10 The invention also relates to reducing food packaging waste and disposal problems as the outer package material requirements may be reduced if the edible product itself is more shelf-stable.

15 Moreover, the invention also allows for the creation of new food products and low fat products that require the use of moisture which heretofore would have had a negative impact on shelf-life.

Description of the Prior Art

20 In many conventional food products, moisture, oxygen, or fat migrates to soften, oxidize or bloom the products, limiting the product's shelf-life. "Shelf-life" is the time that elapses before stored foods become unsuitable for use due to degradation. The migration of moisture, oxygen or other components in foods can cause deleterious changes in the taste, texture, smell, nutritive value, storage stability and saleability of products. "Texture" is the structure, feel, and appearance of a product, including the nature and arrangement of the constituent particles on a substance.

30 The transfer of moisture can occur between a food and its environment and/or within different components of a nonhomogeneous food system. For example, deterioration of the texture of dry bakery materials, such as the crust of a filled pie, occurs when moisture is transferred from the high-moisture filling to the crust. At the same time, the filling changes because of loss of moisture to

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th crust or atmosphere, resulting in a gummy or sticky
consistency.

United States Patent No. 4,707,365 to Haynes et al. discloses that chocolate chips used in cookies lose
5 chocolate flavor impact on aging. This loss of flavor has been found to be due to the higher water activity of the cookie crumb relative to the much lower water activity in the chocolate chips. Specifically, the moisture in the cookie crumb diffuses into the chocolate
10 chips and desorbs the chocolate flavor compounds present therein. These desorbed compounds then diffuse back into the cookie crumbs. The result is chocolate chip cookies which have less chocolate flavor impact over time. The present invention would overcome this problem by
15 providing a moisture barrier coating on the surface of the chocolate chips to prevent the migration of moisture.

Similarly, problems exist when candy coated confections are added instead of, or in conjunction with, chocolate chips to cookies or ice cream products. It has
20 been found that over time the coloring of the candy coating often runs, causing discoloring of the cookie or ice cream. The present invention would overcome this problem by providing a barrier on the candy coating to prevent it from running.

25 Edible films are of tremendous importance because of the impact they have on obviating the problems noted above and on extending the shelf-life of foods. Edible films also expand the opportunities for new foods and increase the consumer expectation for a variety of
30 fresh foods by reducing the requirements for antioxidants and preservatives. There also is a benefit in expanding distribution channels due to extended shelf-life for foods. In addition, the edible films reduce the amount of packaging required to preserve the edible product
35 since the film acts as a barrier to moisture and/or oxygen and improves the shelf-life. By reducing

packaging needs, the edible films have a beneficial effect on environmental regulations and concerns.

The use of edible barriers on food products to minimize the deleterious effects described above is known in the art. However, thus far, the development of edible water and oxygen barriers has focused upon barriers containing organic materials, particularly lipids and proteins. The development of water vapor barriers has centered upon barriers containing primarily cellulose, lipid and protein. In general, barriers containing lipid are less permeable to water vapor than barriers containing proteins. However, protein containing barriers are not practical for certain products, for example fruits.

A non-lipid support is required to reduce the brittleness/fragility associated with barriers containing lipids. Cellulose films are commonly used as a support film. Plasticizers are then added to reduce the brittleness. Proteins can be used in both the support film and the barrier, but these are often not as effective as a lipid barrier.

Recent work has been concentrated on protein and carbohydrate films. Proteins such as collagen, zein, gelatin, gluten and various milk proteins have been the focus of much recent work. Carbohydrates such as chitosan, modified cellulose, and methyl cellulose are also being studied. These materials are useful in many food areas where water activity must be maintained to retain the product's quality and microbial safety. More research is needed before these technologies will become more widely accepted.

The underlying problem with prior art edible films is the large quantities required for the barrier to be effective. The effective quantity is directly related to the coating thickness. With a thicker barrier there is poorer consumer acceptance because a thicker barrier affects the mouth feel quality due to textural

diff r nc s. In general, th more effective coatings
hav poorer mouth fe l quality. An example of this
phenomenon would be a wax film barrier. Wax is an
effective barrier, but with a wax barrier it's necessary
5 to add an amount such that it becomes tough in the mouth
and does not melt (i.e. paraffin wax). Fruits are
sometimes provided with wax layers to increase shelf-life
but these wax layers are detectable by consumers and are
thus undesirable. These waxes, however, decrease
10 moisture loss by a half.

Shellacs are effective moisture barriers, and
are water or solvent disperseable. While solvents are
the most effective dispersant for shellacs they are
undesirable as solvent flavor is absorbed into the food.

15 There are no known edible products that utilize
the insoluble inorganic films that are disclosed by this
invention. Other water based barriers have only a
fraction of the effectiveness in comparison with the
presently disclosed insoluble inorganic coatings, for
20 example a SiO_2 coating. The food industry has thus far
mostly used fat, gums or proteins as barriers. The
primary limitation of these prior art coatings are the
large quantity required to be effective, thus altering
the taste and mouth-feel of the product. In some cases
25 crystallizing proteins or starches on the surface will
improve the moisture barrier for the food. In most cases
those components are soluble in water.

Therefore, ideally, the optimal barrier would
be an ultra thin non-toxic layer which is not perceived
30 in the mouth, and insoluble in water. Such a barrier
would prevent oxygen and moisture migration for long
periods of time.

The following references and those referred to
hereinafter, each of which are hereby incorporated by
35 reference, disclose the stat of the art.

Unit d States Patent No. 2,093,260 to Wilder et
al. discloses the detrimental effect salt has in fat

containing ready-to-eat cereals. When salt is used in the common manner of making these foods, its presence results in appreciable amounts of free hydrochloric acid. The patent discloses a process whereby salt flavor may be obtained without jeopardizing the keeping qualities of food having a substantial fat content by avoiding the addition of the salt to the food until after the completion of the high-temperature operation which results in the decomposition of the fat within the food. (Column 2, lines 49-56). After the high temperature

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toasting operation, the foods are coated with a salt solution and dried to obtain a food product having the essential salt flavoring without its detrimental effects.

United States Patent No. 4,196,219 to Shaw et al. discloses a method of extending the storage life of frozen cooked foods, such as meats, poultry and fish. The method comprises the steps of cooking the food, coating the cooked food with an edible coating having a composition comprising the calcium salt of carrageenan, freezing the food coated with the calcium salt of carrageenan, and storing the coated food in the frozen state. The coating is applied in a substantially uniformly thick coating on the food.

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United States Patent No. 4,288,460 to Ciliberto et al. discloses granular water-soluble food ingredients, which deteriorate upon exposure to the atmosphere, that are protected by encapsulation in a protective coating containing a fatty acid derivative and a flow agent, i.e. fumed silica or carboxymethylcellulose. The resulting coated particles have an improved shelf life and still are substantially instantaneously soluble in water.

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United States Patent No. 4,504,502 to Roland et al. discloses a coated food product formed by applying an aqueous dispersion containing water soluble algin to the surface of a food substrate. The aqueous dispersion has a viscosity effective to substantially uniformly coat the surface of the food substrate. A dry gelling mixture is

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th n applied to th algin coated food substrat for a
p ri od f time suffici nt to form a substantially
continuous edible alginate film along the surface of the
food substrate. The film is sufficient to effectively
5 retard the migration of moisture from the surface of the
food substrate thereby retarding dehydration. The film
also forms an oxygen barrier for retarding oxidation of
the food substrate and retaining flavor within said food
substrate.

10 United States Patent No. 4,802,924 to Woznicki
et al. discloses a method of coating pharmaceutical
tablets, foods, confectionery forms and the like with
polydextrose or a combination of polydextrose and
cellulosic polymer, or a layer of polydextrose overcoated
15 with a layer of cellulosic polymer.

United States Patent No. 5,286,502 to Meyers et
al. discloses a method of prolonging the shelf-life of
sticks of chewing gum by coating both sides with an
aqueous solution of an edible film forming agent,
20 preferably a cellulose derivative, which, when partially
dried, serves as an adhesive. A layer of wax is then
applied to each of the layers of edible film forming
agent.

United States Patent No. 5,298,273 to Ito
25 discloses edible containers suitable for frozen
confections (e.g., ice cream, frozen yogurt and the like)
and other food products made by initially baking a dough.
The method involves sandwiching a farinaceous batter
mixture containing sugar, oil and flour between a pair of
30 heated platens and then heating and baking the batter
mixture to effect alphasatization of the starch and to
evaporate moisture. Thus, after the initial baking, a
de-watered edible sheet of baked batter will result. The
de-watered edible sheet of baked batter is then re-
35 moisturized (e.g., by spraying), molded to form a
container and baked to form a crispy contain r for frozen
confections and other food products.

OBJECTS OF THE INVENTION

It is an object of the present invention to provide a food product having an edible film coating which results in an extended shelf-life for the food product.

It is a further object of the present invention to provide a method for producing an edible product coated with an edible film.

It is still another object of the invention to provide a pre-made sheet of edible material which can be formed and subsequently applied as a coating onto an edible product.

SUMMARY OF THE INVENTION

The present invention relates to an edible film which overcomes the textural problems associated with coating edible products by using a continuous inorganic composition as a barrier layer. It is desirable to produce a layer that is very thin (0.05 micron or less) and amorphous to prevent cracking of the barrier if the product is flexed. The inorganic substance is preferably insoluble.

The main objective of the invention includes improving the shelf-life of food products and/or the flavor impact of food products. The present invention offers several advantages in comparison to current moisture barrier technology. The primary advantage is to increase the shelf-life of food products without effecting the taste and texture. The advantages also include the ability to develop new products with dual textures like crunchy jelly filled confections that would not become soft since the film would form a barrier between the jelly portion and the crunchy portion. Further, the advantages include the reduction of packaging used to protect food products, thereby reducing cost and environmental waste. Moreover, all these advantages are achieved without greatly effecting the look, taste, scent or feel of the edible product.

General Approach

The application of an inorganic film onto an edible product may be performed by a number of methods.

In one preferred method, the product is placed
5 in a batch or continuous system that can produce a plasma. The system can be a simple corona discharge or as complex as a chemical plasma deposition. In any system, a higher success rate is achieved with a drier, more heat resistant, smoother, lower fat and higher
10 density product.

The method preferably is one which enables the formation of a thin inorganic film inexpensively and quickly. A preferred embodiment of the invention includes a process in which the coating step is one of a
15 series of steps in the continuous production of edible products.

The resultant coating covers the edible product to the extent necessary to improve shelf-life by maintaining water activity or retaining flavor. This may
20 result in a coating on the entire product or a portion of the heterogeneous product. For example, a pizza dough that has been baked is coated on one surface so that the high moisture sauce subsequently applied will not effect the baked dough, thereby improving the shelf-life of the
25 product. The invention also allows for differently flavored foods (i.e. crackers) being packed within the same package without detrimental mixing of the flavors.

In some embodiments, there is a barrier to moisture transfer, but not a barrier to the transmission
30 of oxygen, or vice versa. Lowering the oxygen permeability of food products decreases lipid oxidation, nonenzymatic browning and microbial growth. For example, if the edible product is high in polyunsaturated fat, a barrier extremely resistant to oxygen permeability is
35 desired. Conversely, if the edible product is fresh fruits or vegetables, maintaining a proper balance of respiration is necessary to avoid anaerobic respiration

which decreases the consumer acceptance of the product. Accordingly, the inorganic barrier selected has the desired character to result in a coated edible product having the desired properties.

- 5 The edible inorganic film is substantially continuous over at least a portion of, or over the, entire food product. The edible film is also thin (0.0001 to 0.5 microns) so that the product feel, look, and taste are not adversely affected. The edible film is
10 advantageously thin enough, and the amount of inorganic material on the food product is advantageously small enough, so that the resultant coated edible product is within the standards and regulations (such as those published in Section 21 of the Code of Federal
15 Regulations) for edible products.

Coating Systems

- The coating systems that may be used to coat an inorganic material on the surface of edible products include: (1) sputtering or analogous thermal sublimation;
20 (2) electron beam; and (3) plasma deposition. The level of development of the technology relating to the coating of inorganic materials has been intense in recent years. Both the biomedical and electronics fields have been involved in the technology because inorganic films have
25 great utility in these areas as well.

- Since high heat and/or low vacuums are often needed to make a plasma, care must be taken to avoid changing the products' composition or texture, for example, evaporation of moisture on the surface which is
30 being coated. Lower vacuum processes are preferable if done at ambient or low temperature. Drier foods have shown a higher success rate as evaporation at the surface of the food is minimal if the food has a low moisture content. In certain applications, depending on the type
35 of food product, it is also possible to freeze the food product to prevent vaporation.

Sputt ring or analogous thermal sublimation systems take a targ t composition and bombard it with ions which have been accelerated towards the target by high radio frequencies or direct current potential. The momentum of the impacting ions transfers energy to the surface atoms of the target causing them to be ejected at high velocities onto the substrate to be coated.

An electron beam process imparts ample energy to sublime the substrate in a vacuum. However, the sublimation temperatures are generally too high for some edible products and the energy levels of the e-beam are ~20-40 kilowatts per gun and require nuclear shielding. While an electron beam process may be utilized it is more expensive, making it less attractive for food industry applications.

Plasma enhanced chemical vapor deposition is activated by means of electromagnetic energy which must be sufficient so that the gas or liquid separates into electrons, ions, and free radicals and other excited state species. "Plasma" is an ionized gas which contains substantially equal numbers of ions and electrons. The precursor compound is vaporized and introduced into a vacuum chamber where it is subjected to an electronic discharge. The electromagnetic field causes electrons to be ejected, creating ions and initiating a chain reaction to generate more charged particles. The excited species of gas in the glowing plasma is attracted to the surface of the food where the excited and neutral species of the compound are deposited on the substrate surface and built up atom by atom until a continuous layer is formed.

Microwave plasma enhanced chemical vapor deposition uses microwave energy in addition to the above process. This creates a similar product as described above.

The frequencies typically used in ch mical plasma depositions range from about 10 KHz to about 1 GHz, preferably 10 KHz to 100 MHz, and pressures vary

from about 0.00001 t ab ut 50 torr. The power coupling can be capacitiv , inductiv or microwave.

While any of the above described coating processes may be employed the preferred method of coating the edible product is by chemical plasma deposition (CPD) if the products are required to be very uniform. Sputtering is the preferred method when high degrees of control are not needed, but rather less expensive production costs are important. The main advantage with CPD is that the process can be performed at lower vacuums and temperatures than sputtering. The main advantage of sputtering is that it reduces the possibility of side reactions which can form contaminates in the coating. Both sputtering and CPD are processes that have been improved and developed over the last 15 years by the electronic and biomedical fields. Also, CPD films have now been approved by the FDA for the flexible packaging on food contact surfaces.

In chemical plasma deposition a thin film depositing plasma is formed in a chamber by introducing at least one gaseous precursor into a region having a controlled electrical field. The process parameters that are usually controlled include the internal pressure level, the electrical field characteristics, the composition of the gas and its flow rate into the plasma. Varying these parameters will vary the characteristics and properties of the resultant film. It is, of course, desirable to control these plasma variables to produce a film coating having the desired film properties. As applied to the present invention, it is necessary to adjust the parameter to result in a film coating being substantially continuous, as well as having a uniform thickness and composition.

One method, disclosed by Felt et al. in U.S. Pat nt No. 4,888,199, involves a process of depositing a thin film onto a surfac of a substrat with the us of a plasma, wherein the plasma optical emission is monitored,

analyzed and the results used to automatically control the nature of the plasma in order to control the characteristics of the deposited thin film.

The Edible Substrate Material

5 "Edible product" refers to either a food product or a pharmaceutical which can be consumed by humans or nonhumans (i.e., pets). The edible product can also include foods that are to be used only for display. The properties of the edible product to be coated, such
10 as its surface smoothness, moisture content, heat resistance, fat content and density play an important consideration in the selection of the types of edible substrate material and its method of application. Optimal results are achieved when the food surface is
15 smooth and dry. With a smoother surface a thinner coating has been found to be effective. The surface moisture of the product is also an important consideration since it is more difficult to coat a surface which is evaporating. More heat resistant
20 products enable the use of lower pressure or vacuum processes and higher process temperatures to maintain the plasma which lower manufacturing costs. Higher fat products are non-polar making it more difficult for the coating to adhere to the surface. The surface will
25 change due to the polymorphic nature of fats. Fats will change crystalline structures over time to achieve its lowest thermodynamic state. The polymorphic changes are generally to larger crystal sizes. This polymorphic expansion may cause cracking or irregularities in the
30 coating. These problems are overcome by using edible products having a surface with a low fat content.

Also higher density products react better in a vacuum process because they will not expand. Products that expand could develop cracks in the coating and
35 decrease the edible film's effectiveness. Freezing the products before the process may decrease many of these problems. However, since coatings formed by sputtering

and CPD are amorphous and therefore inherently flexible, the problem of cracks caused by substrate expansion is not significant.

In another embodiment of the invention a
5 precoating edible barrier is applied which covers some of the voids in the edible product, resulting in a smoother surface. This product is then coated with an inorganic layer. Such a process is beneficial in edible products where an enzyme or acid/base reaction could degrade the
10 precoating. When that occurs the inorganic layer for barrier protection remains. This process is commercially important as it avoids the associated problems and expense of producing a plasma deposition at the food manufacturing plant.

15 Examples of some of the possible existing types of edible products that may be coated according to the present invention include:

Low moisture foods that need expensive barrier protection to prevent them from being soggy.

20 Hard candy that becomes sticky when exposed to high humidities.

Cookies and potato chips that also become soggy or stale when the bag is opened or stored for long periods of time and lose their crunch.

25 Food products that are for display, thereby requiring long shelf-lives. These products discolor and crack with time due to moisture loss.

Sugar coated confections/pharmaceuticals to prevent the color coating from rubbing off on the hands.
30 Air and humidity solubilizes the coating sugars that carry the coloring.

Ready to eat cereals that when served in milk become soggy with time.

Cookies with jelly topping of chocolate chips
35 which become soggy or lose chocolate flavor over time, thereby reducing shelf-life or taste.

Low fat systems which generally reduce fat by adding water, and which dry out over time limiting shelf-life.

The present invention enables the creation of otherwise impractical low fat/high moisture products by forming a moisture barrier film on high moisture foods to prevent the dehydration of the product. Accordingly, high moisture foods, such as low fat systems, with long shelf-life are achieved.

Oxygen sensitive systems containing nuts or milk fat that become rancid with time as oxygen migration, and thus lipid oxidation, are reduced by the present invention.

Other products for which the present invention is beneficial are highly flavored snacks of different flavors. At present these need to be packed in different containers or the flavors will be exchanged, thus altering the quality of the product. With the barrier coating of the present invention they can be packed together. For example, products such as chips or other products coated with an inorganic film would form an aroma barrier, making it possible for multi-flavored chips to be packaged within the same container as well.

The Composition of the Inorganic Coating

The coating composition may be any inorganic material. Preferably, the coating material is GRAS certified (Generally Recognized As Safe) by the Food and Drug Administration or can be readily certified as GRAS. More preferably, the coating material forms a barrier against moisture and/or oxygen migration. The preferred coating compounds include SiO_2 , SiO , CaO , ZnO , TiO_2 and MnO . SiO_2 is desirable in that it is GRAS certified, forms a good barrier and has been used as an ultrathin coating in other fields, such as electronics. CaO is also desirable because of its well known nutritional value. It is particularly preferable to coat SiO_2 , MnO , CaO and TiO_2 on surfaces of foods since these compounds

are either approved additives, approved dietary supplements, or approved color additives. It is also possible to coat other fortifying minerals on the surface of foods.

5 The inorganic coating composition is also preferably insoluble or only dispersible in water. "Dispersible" is defined as being the phase of a disperse system consisting of particles or droplets of one substance distributed through another system. This is to
10 insure the resultant films form a lasting effective moisture barrier so that the shelf-life of the product is improved.

 The purity of the coating should be controlled in order to insure the resulting edible product is safe.
15 "Purity" is defined as being substantially free from anything that adulterates or taints the edible product. In particular, the term refers to the coating composition being free from contaminants that would affect the safety of the product. Generally the coating composition should
20 be at least 80% pure, preferably at least 90% pure, more preferably at least 95% pure, even more preferably at least 99% pure and most preferably at least 99.9% pure.

 SiO₂ is particularly advantageous since it is an approved additive ingredient that can be used in food
25 up to 2.0 wt%. Furthermore, SiO₂ powders are already commonly used as anti-caking agents. In addition, SiO and SiO₂ are currently used in coatings on plastics and glasses to improve oxygen barrier properties. Considered to be retortable and recyclable microwave barriers,
30 glassy materials on plastics were applied to packaging to provide a high oxygen barrier to plastic package films or bottles that were transparent to microwave energy. See, Brody, A.L., "Glass-coated Flexible Films for Packaging: An Overview", Packaging Technology & Engineering,
35 February 1994, pages 44-47, hereby incorporated by reference.

The coating compositions of the present invention may comprise a mixture of SiO and SiO₂. The coating composition may be given the designation SiO_x because the composition is a mixture, wherein $1 \leq x \leq 2$.

5 Various compounds utilized as the Si source for chemical vapor deposition (CVD)/chemical plasma deposition (CPD) include organosiliconic esters, anhydrides (often referred to as organosilicates), silane (SiH₄), disilane (Si₂H₆), and chlorosilanes. Also,
10 included is tetraethoxysilane, (Si(OC₂H₅)₄), also known as tetraethylorthosilicate (TEOS). See, Tedder et al., "Mechanistic Studies of Dielectric Thin Film Growth by Low Pressure Chemical Vapor Deposition: The Reaction of tetraethoxysilane with SiO₂ Surfaces", Journal of Applied
15 Physics, volume 69(10), May 15, 1991, pages 7037-49, hereby incorporated by reference.

Another known precursor for use in plasma deposition includes a mixture of HMDSO (hexomethylene disiloxane), O₂ and He.

20 A low temperature CVD of SiO₂ films is disclosed in Desu et al., "Low temperature CVD of SiO₂ Films Using Novel Precursors", J. Electrochem. Soc., vol. 139, no. 9, September 1992, hereby incorporated by reference. Novel precursors, hydridospheresiloxanes,
25 namely, HT8(O_n-H₈Si₈O₁₂) and HT10(D_{5n}-H₁₀Si₁₀O₁₅), are taught for use in SiO₂ deposition in high yields starting from HSiCl₃. This procedure results in excellent quality SiO₂ thin film deposited on a single crystal silicon substrate. The films are grown at 500°C and at
30 atmospheric pressure using moist oxygen as a coreactant.

The Coating

The resultant coating should be substantially continuous. "Substantially continuous" is defined as being at least 80% continuous, preferably 90% continuous,
35 more preferably 95% continuous and most preferably 99% continuous. Although cracking, chipping or incomplete application of the coating may reduce the effectiveness

if the barrier, such a coating still achieves a reduction in the effects of moisture and/or oxygen migration in the food product. Optimally, however, a continuous coating should be formed as the less continuous the coating, the less effective the barrier mechanism. The inorganic coating should be continuous over at least a significant portion of the edible product and preferably over the entire surface of the edible product. The coating should be thin to reduce the chance of cracking or chipping.

10 The coatings formed by sputtering and CPD are amorphous, which provides flexibility to further prevent cracking or chipping. The flexible character of the coatings can be increased by adding additives during the coating process.

15 The thickness of the coating is also an important consideration. The thickness of the coating is proportional to the weight percentage of coating composition with respect to the weight of the edible product. It is often preferred or required to maintain
20 the content of the coating composition to a minimum because of safety concerns or regulatory requirements. In addition, the thickness of the coating is also important since it can affect the character of the edible product, including the product's taste, texture and
25 smell. Also, the thickness of the coating ultimately determines the effectiveness of the film as a barrier.

 Since the mouth can detect particle sizes of 20 microns or greater as gritty or chalky the inorganic coating should have a thickness of less than about 0.5
30 microns. Preferably, the inorganic film should have a thickness of about 0.0001 to 0.2 microns, more preferably about 0.0001 to 0.1 microns, even more preferably about 0.0002 to 0.05, and most preferably about 0.0005 to 0.02 microns.

35 The inorganic coating should also be substantially uniform in both its thickness and composition. "Substantially uniform" is defined as being

that uniformity necessary to result in a product having the desired properties, preferably with less than a 100% variation, more preferably less than 50% variation, even more preferably less than 25% variation, and most preferably less than 10% variation.

The amount of coating used to cover the edible product is to be controlled so that the resultant product is safe. This will depend on the edible product and the coating materials used. Generally, the amount of coating composition in the resultant edible product should be less than about 0.05 wt%, preferably less than about 0.01 wt%, more preferably less than about 0.005 wt%, even more preferably less than 0.001-0.002 wt%, most preferably less than about 0.0005 wt%.

Additional objects, advantages and features of the various aspects of the present invention will become apparent from the following description of its preferred embodiments, such description being given in conjunction with the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 illustrates an elevational view in section of a portion of an elliptical edible product covered by a sugar coating, a polish and finally an edible inorganic coating;

Fig. 2 illustrates an elevational view in section of a portion of an elliptical edible product having a first sugar shell, then an inorganic edible precoating and then covered by a polish coating;

Fig. 3 illustrates a perspective view partly in section of an edible bar product in accordance with a preferred embodiment of the present invention an edible bar product coated with an edible inorganic coating and then covered with a second coating;

Fig. 4 illustrates a perspective view partly in section of an edible bar product in accordance with a preferred embodiment of the present invention of an

edible bar product pre-coated with an edible inorganic coating and then covered by a second edible coating;

Fig. 5 illustrates a perspective view partly in section of an edible bar product in accordance with a preferred embodiment of the present invention of an edible bar product coated with an edible inorganic coating;

Fig. 6 is a schematic flow diagram for a batch apparatus used for coating edible products with an edible film;

Fig. 7 is a schematic flow diagram for a continuous apparatus used for coating edible products with an edible film; and

Fig. 8 is a schematic flow diagram for a batch apparatus to produce an edible film on a film product.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

Referring initially to Fig. 1, an edible product is illustrated that includes an elliptical chocolate product 1 coated with a first sugar coating to form a sugar shell 2, further coated with a polish 3, and finally coated with an inorganic coating 4.

Fig. 2 illustrates an elliptical chocolate product 5 coated with a sugar shell 6, further coated with an inorganic coating 7 and finally coated with a polish 8.

Fig. 3 illustrates an edible product comprising a center of confection components 9 coated with an inorganic coating 10, and finally enrobed in a chocolate coat 11.

Fig. 4 illustrates an edible product comprising a center of confection components 12 coated with an inorganic coating 13 and finally enrobed in a chocolate coating 14.

Fig. 5 illustrates an edible product comprising a center of confection components 15 coated with a chocolate coating 16, and finally coated with an inorganic coating 17.

Fig. 6 illustrates a batch sputtering process where the food to be coated is placed in an enclosed plasma deposition apparatus 17 in plasma deposition area 19. After door 18 is closed, a vacuum is pulled by pump 20, and the enclosed area is back flushed with an inert or reacting gas through supply line 21 and brought up to processing vacuum. An electrical current from a suitable power source (not shown) is supplied through electrodes 22 to create the plasma. After adequate time for coating the product, electrical current and pump 20 are shut off and gas 21 exhausted to permit door 19 to be opened and the coated product removed.

Fig. 7 illustrates a continuous system for a plasma depositor. In the continuous process for plasma deposition three separate enclosed chambers 1, 2 and 3 are used with each chamber being under separate vacuum control. Product enters chamber 1 on conveyor belt 28 through a star valve 25 which precludes entry of outside air. A vacuum is maintained in chamber 1 by pump 26 through valve 27 and an inert or reactive gas through supply line 29 flushes the product. Conveyor belt 28 moves the product through star valve 30 into chamber 2. Star valve 30 isolates chamber 1 from chamber 2. After passing through star valve 30 the product is deposited on conveyor belt 31 to plasma depositing area 32. Plasma is created by electrical current from a power source (not shown) supplied through line 33 to electrodes 34 in the presence of the inert or reactive gas and vacuum is maintained by pump 35. The plasma coats the product. The coated product then passes through star valve 36 to chamber 3 on conveyor belt 37. A vacuum less than that in chamber 2 is maintained in chamber 3 by pump 38. The product then exits chamber 3 through star valve 39 and onto a conveyor belt to the conventional food processing line.

Fig. 8 illustrates a sputtering depositor that coats a sheet of edible inorganic film onto a flexible

sheet 49. The edible coating can be subsequently separated from the flexible sheet 49 and incorporated into products such as those shown in Figure 4. A pre-made flexible sheet 49 is placed in a chamber 43. The flexible sheet is unrolled from feed drum 40 over a chill roll 41. The inorganic target 48 is placed on a plate 50 and sputtered onto flexible sheet 49 by applying electrical energy through supply 47 in the presence of gas obtained from gas supply 44 regulated by a valve 45. The coated flexible sheet 51 is then taken up by take-up drum 42. The vacuum, power, and gases are shut off before the product is removed. The process is somewhat similar to the deposition system of Fig. 6, as a vacuum is pulled in chamber 43 first to remove air by one or more pumps 46 and reacting and/or inert gases are introduced into the chamber for the deposition process. However, unlike CPD, where the gas is ionized and the charged ions attracted to the product, in sputtering, charge particles are accelerated into the target which results in particles from the target being ejected onto the substrate, here flexible sheet 49. The resultant pre-made sheet of inorganic material may be stored, separated from the flexible sheet and applied onto an edible product as a barrier.

25

EXAMPLES

Experiments have been completed using both Sputtering and Chemical Plasma Depositions (CPD) techniques. In both cases, the outer polish coating used on certain products appear to cause the SiO_2 to produce dusty patches on the coated product. Also, it was discovered that a certain operating wattage range (about 50 watts) was preferable for products with low melting temperatures, such as chocolate products (melting temperature about 20°C).

35

Sputtering is a more severe vacuum process than CPD. Also, CPD places an estimated 1000 angstrom layer on the product about 10x times faster than sputtering.

CPD produced a coating comparabl to that produc d by sputtering, but at only 50 Watts.

EXAMPLE 1

The edible product used was SKITTLES® Bite Size
5 Candies. Theses are a sugar coated fruit flavored toffee candy. In the manufacture of SKITTLES® Bite Size Candies, sugar is mixed with the flavor to form the toffee. The toffee is then formed into an elliptical center. The center is then coated with a sugar solution
10 and air dried. The product is polished and finally printed with the letter S. SKITTLES® heretofore have exhibited adverse effects when exposed to excessive moisture for long periods.

The SKITTLES® product was placed into a
15 reaction chamber of a laboratory apparatus of the type shown in Fig. 6 and the door of the chamber closed. A vacuum was then pulled to a base pressure of 50-200 mtorr. The chamber was flushed with Argon at 45 sccm and then by oxygen at 8 sccm until the chamber was full of
20 pure oxygen. The TEOS (tetraethylorthosilicate) tube was heated to 95°C to vaporize the TEOS before entering the chamber. The power was turned on to about 50 watts and fed through an RF coupling device that was set at 13.56 MHZ. The plasma was started and the TEOS valve was
25 turned on to allow the TEOS to react with the oxygen in the plasma and coat the SKITTLES® Bite Size Candies. After 10 minutes the power, the oxygen and TEOS gases and lastly the vacuum pump was shut off. The chamber was opened and product was removed.

30 Preferably the electrical power should be supplied to the bottom plate and the product set on this bottom or "hot" plate. Alternatively, the power may be supplied directly to the edible product if it is conductive. This procedure allows the SiO₂ to directly
35 coat the surfac with reduc d dusting. This is due t the positive nature of SiO⁺ from the TEOS. In any case, the process resulted in the reduced dusting of the SiO₂

the surface that was formed in the plasma and coated with the product. Thus, the SiO_2 was placed on the product without dusting.

Conditions:

	<u>Range</u>	<u>Ideal</u>
5		
Electrode Separation	1-3 inches	(1.5)
Electrode Area	15-50.0 inches	(32.0)
Argon Flow	25-100 sscm	(45
sscm)		
10 Oxygen Flow	1-20 sscm	(8
sscm)		
TEOS temperature	85-110°C	(95°C)
RF (13.56MHZ)	25-100 watts	(50
watts)		
15 Deposition time	5-25 minutes	(15
mins)		
Base pressure	50-500 mtorr	
(200mtorr)		

20 The coated SKITTLES® were tested by evaluating the effects of exposure to moisture. An uncoated SKITTLES® was placed in a vial of water and began dissolving immediately. A SKITTLES® coated with the inorganic film was placed in a vial of water and did not
 25 begin to dissolve until after 4 minutes. It is believed that this time can be still further increased if 'pin holes' present in the coating are reduced or eliminated and a more even inorganic coating is placed on the product. It is envisioned that with a more carefully
 30 constructed apparatus the number and size of 'pinholes' will be reduced.

EXAMPLE 2

In this example, TWIX® Caramel Cookie Bars are used. Twix® Bars are cookies that are topped with a
 35 caramel coating then enrobed with chocolate. This type of product is illustrated in Fig. 4. The shelf-life is somewhat limited due to water migration from the caramel to the cookie. This water migration softens the cookie and with age a poorer quality product than initially
 40 manufactured results. In this example, the pre-process

apparatus is installed before an apparatus as illustrated in Fig. 7 to produce a cookie cut into bar lengths. Then the product is passed through the star valve 25 which is designed to allow for the insertion of the product into a chamber 1 where a vacuum was pulled to 20 torr without dropping the vacuum level. The product then passes through star valve 30 to chamber 2 where the plasma coats the product with the inorganic layer. After coating the product passes through star valve 36, into chamber 3 which is maintained at a vacuum of 30 torr. After passing through star valve 39 the product exits having been coated with an inorganic film. The product then continues on the conventional confectionery line for further processing. The barrier on the cookie reduces the migration of moisture and oxygen to and from the cookie, thereby increasing the shelf-life of the product.

EXAMPLE 3

This example uses "M&M's"® Chocolate Candies which are elliptically shaped chocolate centers coated with a sucrose solution containing coloring to form a candied coating. The color coating on the "M&M's"® Chocolate Candies eventually rubs off in time when exposed to humid conditions. To increase the quality of the confection a moisture barrier according to the present invention is desirable. In this example a batch process which entails placing a perforated bed rotating pan ("perforated tumbler") inside a plasma reactor similar to Fig. 7, is employed. The product is placed into a tumbler which is then placed into chamber 1 and then a vacuum is pulled to 0.1 torr. The tumbler is then back flushed with O₂ to a vacuum of 10 torr. The tumbler is then set into motion into chamber 2 and the plasma starts to coat the product. After coating, the chamber is pressurized and product removed from the tumbler. The inorganic coating on the chocolate candies improves the shelf-life and quality of the product by reducing the deleterious effects of exposure to moisture.

EXAMPLE 4

In this example, coated chocolate chips or coated "M&M's"® Chocolate Candies or "M&M's"® Milk Chocolate Baking Bits are used. These types of candies generally bleed their color into food products, such as cookie or ice cream products when they are added to such products. This produces a "halo" or color ring within the product that in some cases is not aesthetically appealing. Products and/or their ingredients are coated similar to EXAMPLE 2 (see Figures 1 and 2) to reduce this discoloring. The coated products are incorporated into cookie or ice cream products without the resultant "halo formation".

EXAMPLE 5

Coated "ready to eat" cereals become soggy in milk soon after the milk is added to the cereal. By the time the consumer finishes the bowl, the cereal is generally soggy. With the exception of sugar coated cereals, this attribute lowers the eating appeal of the food product. It is possible to reduce moisture migration with the technology of the present invention by coating the cereal with an inorganic coating, without the need to add extra sugar. Because cereals are already fortified, this coating will add to the mineral and nutritional claim if the inorganic film contains nutrients. A process to coat cereals may be performed using the apparatuses shown in Figs. 6 and 7. The barrier formed on the cereal will be optimized so that the product does not become soggy when mixed with milk. Since the cereal product is only exposed to milk for a relatively short period of time (1-10 minutes), the coating thickness can accordingly be adjusted. If an oxygen/moisture barrier coating is used the resultant product will also have a longer shelf-life due to decreased oxygen migration. The product will therefore be less likely to become stale.

As illustrated by the foregoing description and examples, the present invention has great application for the formulation of a wide variety of edible products. The present invention provides for edible products having
5 extended shelf-life and uses without detrimentally affecting the taste, texture and smell of the product. The present invention allows for the reduction of the cost of packaging without reducing the shelf-life of the product as less expensive packaging may be used instead
10 of more costly foil or barrier packaging materials. This is a further environmental benefit in that such expensive packaging material are not readily biodegradable.

The terms and expressions which have been employed are used as terms of description and not of
15 limitations, and there is no intention in the use of such terms or expressions of excluding any equivalents of the features shown and described as portions thereof, its being recognized that various modifications are possible within the scope of the invention.

We claim:

1. A coated edible product comprising:
 - a. an edible material; and
 - b. an inorganic coating on the edible
- 5 material, wherein a substantially continuous inorganic coating covers at least a portion of the edible material.
2. The coated edible product of claim 1, wherein the inorganic coating forms a barrier that reduces the migration of moisture and/or oxygen.
- 10 3. The coated edible product of claim 1, wherein the inorganic coating has a thickness of less than 0.5 microns.
4. The coated edible product of claim 3, wherein the inorganic coating has a thickness of 0.0002
- 15 to 0.2 microns.
5. The coated edible product of claim 4, wherein the inorganic coating has a thickness of 0.0002 to 0.1 microns.
6. The coated edible product of claim 5,
- 20 wherein the inorganic coating has a thickness of 0.0002 to 0.05 microns.
7. The coated edible product of claim 1, wherein the inorganic coating forms a substantially continuous layer on the entire surface area of the edible
- 25 material.
8. The coated edible product of claim 1, wherein the inorganic coat is at least 95% continuous.
9. The coated edible product of claim 1, wherein the inorganic coating comprises at least one
- 30 compound selected from the group consisting of SiO_2 , SiO , CaO , ZnO , TiO_2 and MnO .
10. The coated edible product of claim 1, wherein the inorganic coating consists essentially of SiO_2 , SiO , CaO , ZnO , TiO_2 or MnO .
- 35 11. The coated edible product of claim 1, wherein the inorganic coating consists essentially of a mixture of SiO and SiO_2 .

12. The coated edible product of claim 1,
wherein the inorganic coating is substantially pure.

13. The coated edible product of claim 1,
further comprising a precoating material which is applied
5 onto the edible material before the inorganic coating.

14. The coated edible product of claim 1,
wherein the inorganic coating separates the edible
material and a water-containing filling.

15. The coated edible product of claim 1,
10 wherein the coated edible product comprises more than one
inorganic coating.

16. The coated edible product of claim 1,
wherein the inorganic coating is 0.0001 to 0.05 wt% of
the coated edible product.

17. The coated edible product of claim 1,
15 wherein the edible material is substantially solid.

18. The coated edible product of claim 1,
wherein the edible material is a gel.

19. A method of producing an edible product
20 having an inorganic coating, which method comprises
coating the edible product by plasma deposition with a
substantially continuous coating of inorganic material
that covers at least a portion of the edible product.

20. A method of producing an edible product
25 having an inorganic coating, which method comprises
coating the edible product by sputtering a substantially
continuous coating of inorganic material onto the edible
product.

Fig. 1

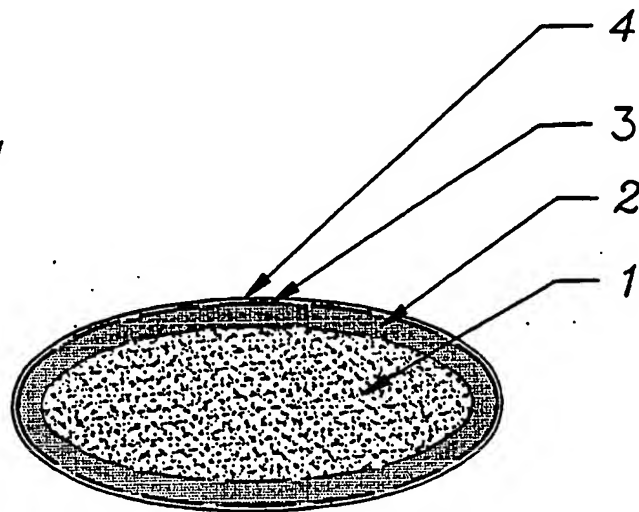


Fig. 2

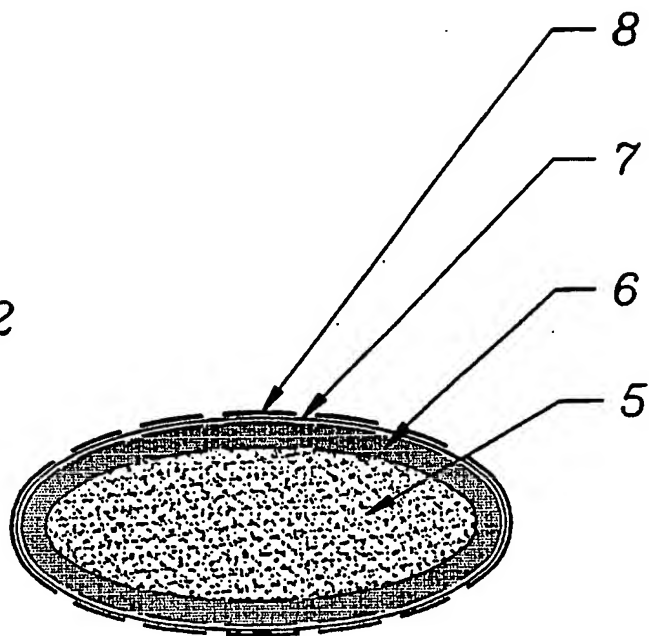


Fig. 3

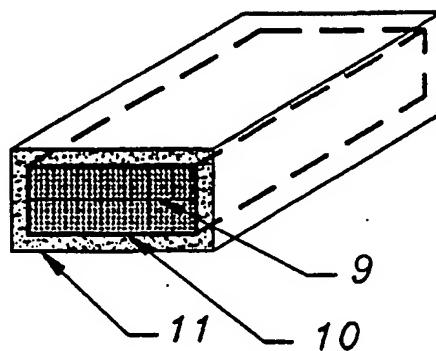


Fig. 4

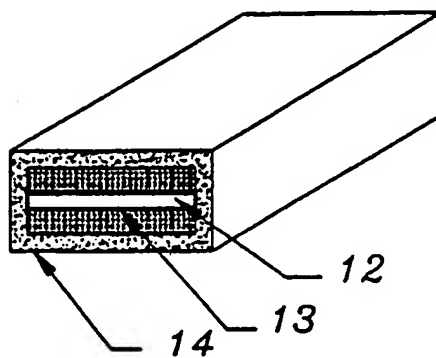
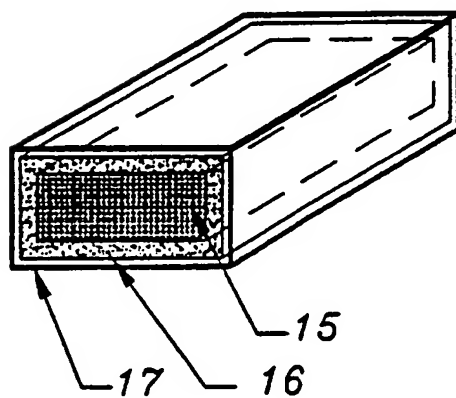


Fig. 5



3/3

Fig. 6

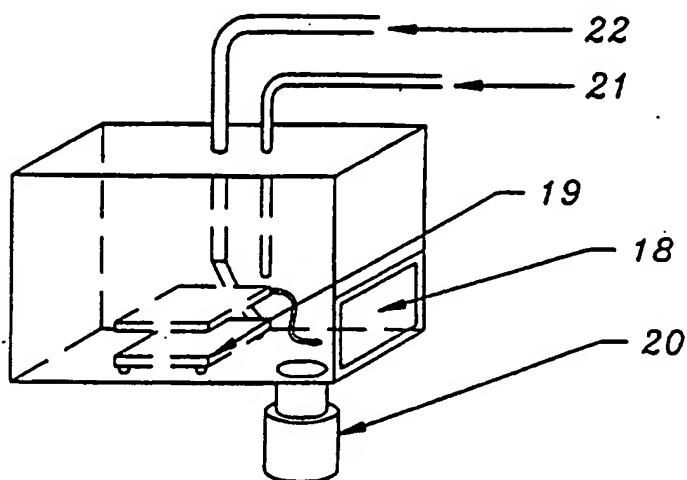


Fig. 7

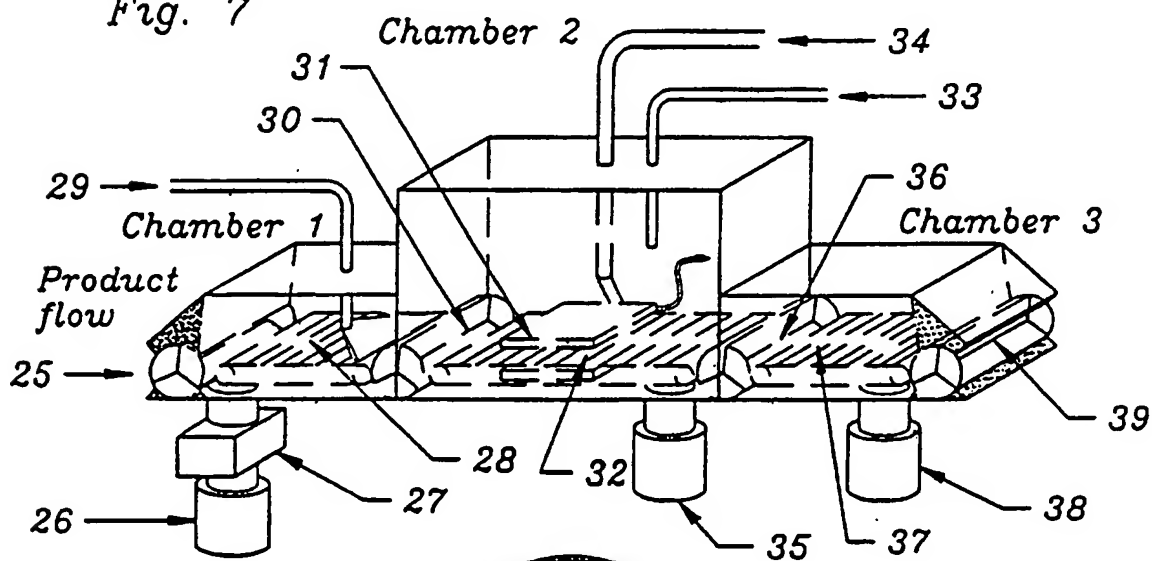
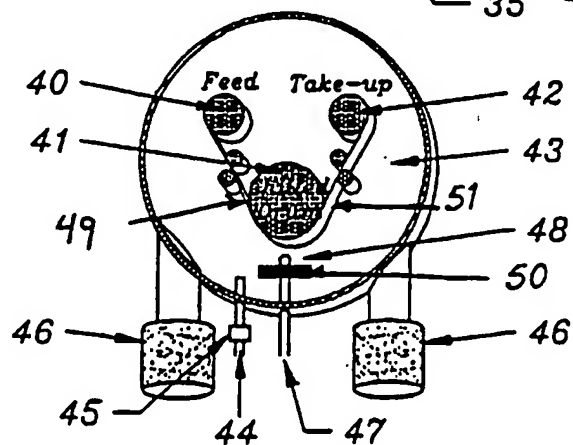


Fig. 8



INTERNATIONAL SEARCH REPORT

International application No.
PCT/US96/00806

A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) : A23L 2/00

US CL : 424/264; 426/94

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 424/264, 474, 439; 426/94, 89, 93, 96, 97, 98, 138, 139, 140, 282, 284, 289, 292, 322, 654

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X --- Y	US, A, 4,278,695 (VELASCO) 14 July 1981, column 1, lines 49-53 and column 2, lines 14-24	1, 2, 7-12, 17 ----- 3-6, 13, 15, 16, 18-20
A	US, A, 5,297,273 (ITO) 29 March 1994.	1-20
A	US, A, 4,888,199 (FELTS ET AL.) 19 December 1989.	1-20



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:	*T	later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
A document defining the general state of the art which is not considered to be of particular relevance	*X*	document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
E earlier document published on or after the international filing date	*Y*	document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
L document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	*Z*	document member of the same patent family
O document referring to an oral disclosure, use, exhibition or other means		
P document published prior to the international filing date but later than the priority date claimed		

Date of the actual completion of the international search

28 MAY 1996

Date of mailing of the international search report

03 JUN 1996

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